

Date: Monday, 10/22/2007 10:34:25 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	AFT CROSSTUBE
Job Number	35261		
Estimate Number	10377		
P.O. Number	N/A	Part Number	D2890
This Issue	10/22/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2890 REV B
First Issue	N/A	Project Number	N/A
Previous Run	35260	Drawing Revision	B
Written By		Material	N/A
Checked & Approved By		Due Date	11/5/2007
Comment	Est. D 05.03.21	Removed Bending procedures	KJ/JLM

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6008180	Crosstube extrusion	
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 1.0000 Each(s)	
Pick:			
Qty	Part #	Description	Batch
1	D6008-180	Crosstube extrusion	033967 *
2.0	BENDING	BENDING MACHINE	
Comment:	BENDING MACHINE		
1-Bend D2890 as per Dwg D2890 and Folio FT002			
3.0	QC6	DIMENSIONAL CHECK	
Comment:	DIMENSIONAL CHECK		
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1	
Comment:	LANDING GEAR RESOURCE 1		
1-Deburr and Polish			
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
Comment:	HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/10/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 10:34:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 35261

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



NIA



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W10 35223 - 107

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

10/22/07

Job Completion



U Oct 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

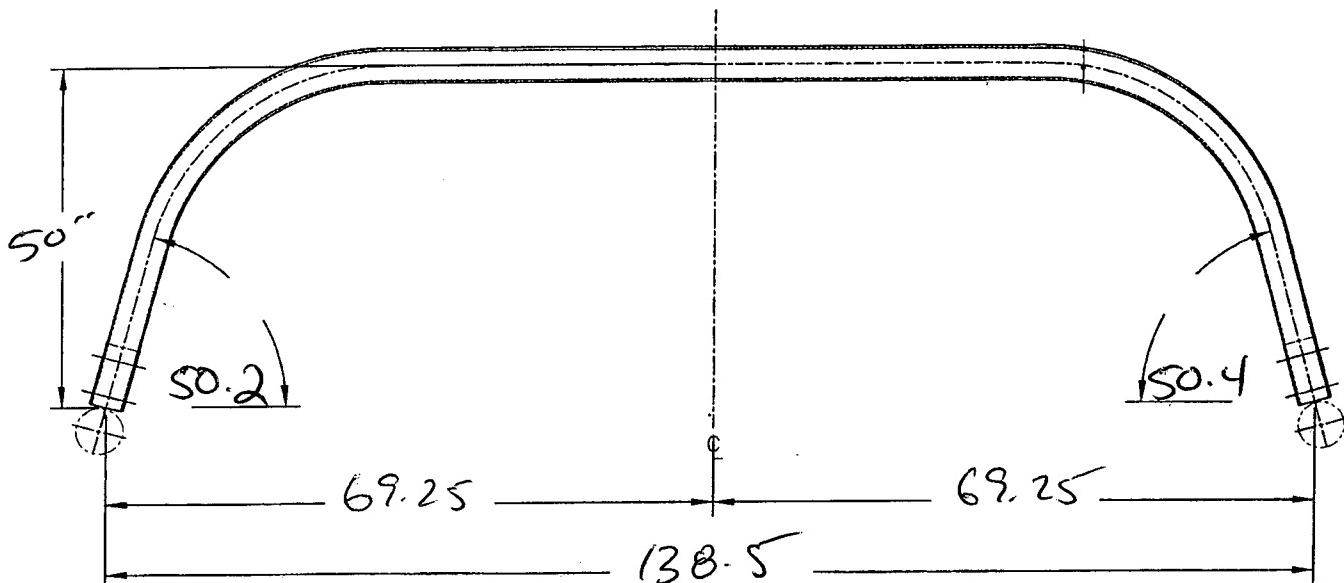
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	35261
Description: Crosstube Aft	Part Number:	D2890
Inspection Dwg: D2890	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments

QC15 Inspection	<i>[Signature]</i>
Date	09-10-29

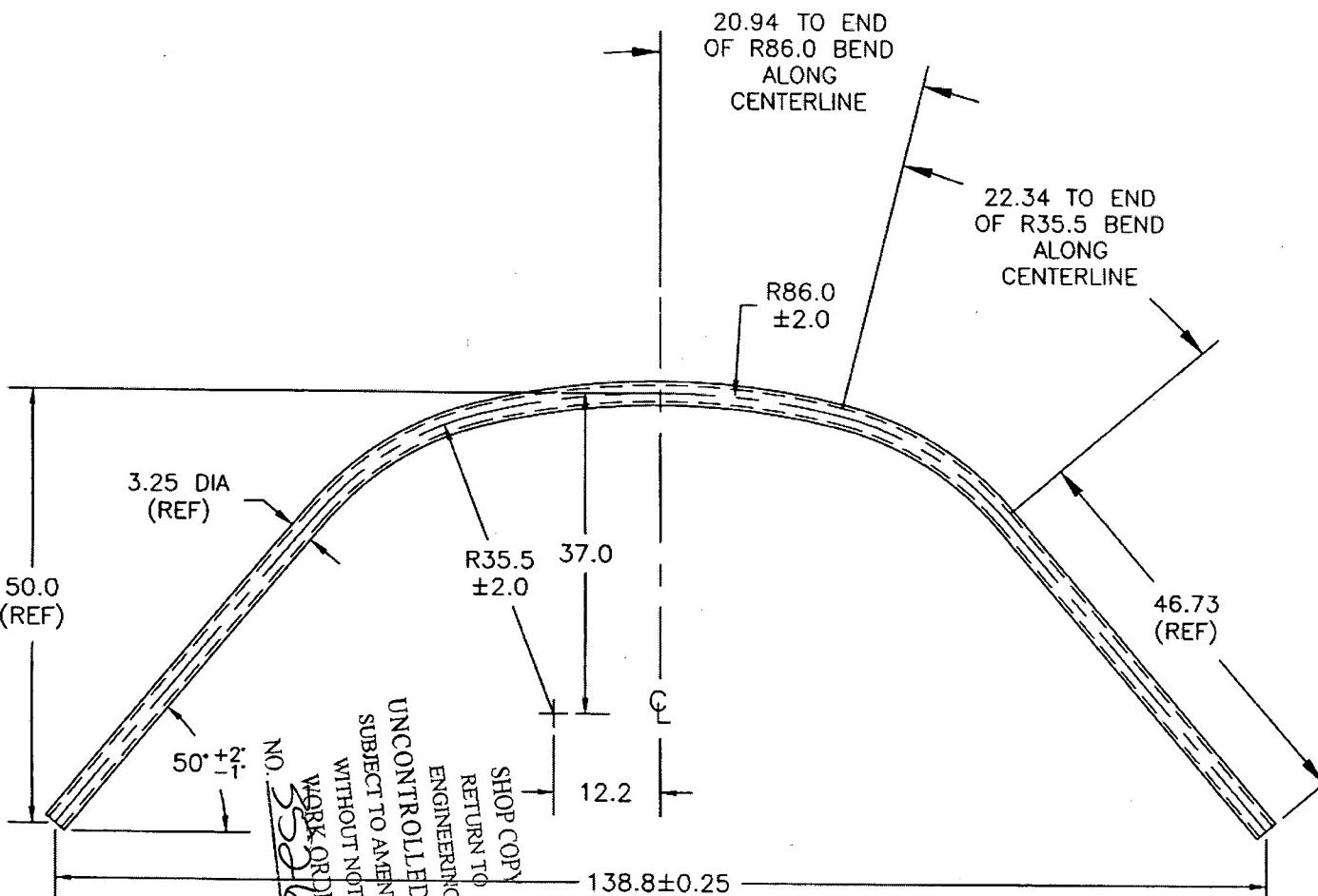
Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2890	SHEET 1 OF 1
DATE			SCALE
02.10.18		AFT CROSSTUBE	1:20
A	99.05.21	NEW ISSUE	
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES	

RELEASED
02.10.28



NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ($\varnothing 3.25$ OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

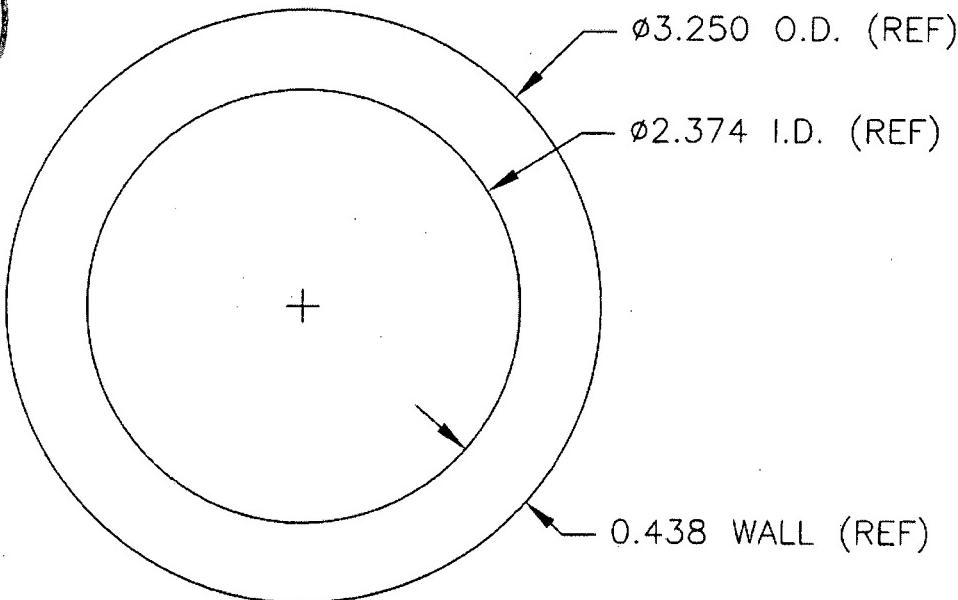


1 COPY ISSUED
CFS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6008
DATE		REV. A SHEET 1 OF 1 SCALE 1:1
00.11.17		TITLE CROSSTUBE MATERIAL
A	00.11.17	NEW ISSUE

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24 #



NOTES

1) D6008-XXX CROSSTUBE
 |
 | LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 180" LONG TUBE: D6008-180

- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
OD: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX +0.125/-0.000
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHHOLD NOTICE
WORK ORDER
NO. 3526 |

Copyright © 2000 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.